

Work Order ID 66939

Thursday, March 03, 2011 8:43:39 AM



Page 1

Item ID: D2022-101

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacer

Start Date: 3/3/2011 Start Qty: 40.00

Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 40.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-03-3

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



Hardinge

0.00

Hardinge CNC Lathe Small

Memo:

Note: .257" dia drill
1-Turn as per folio FA206 & dwg
FOLIO REV: _____
DWG REV: _____

2-Deburr as required

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

11/3/10

11/3/10

60 6

60 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66939

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Item ID: D2022-101

Accept

Revision ID:

Item Name: Spacer

Start Date: 3/3/2011 Start Qty: 40.00

Required Date: 3/11/2011 Req'd Qty: 40.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

K.A 11/03/10

60

0

130

Identify as per dwg & Stock Location: 504

0.00



Packaging

Memo

0.00

Packaging

counters

11/3/11

60

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/11

ME
11-03-10

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NOTE: Date & initial all entries

Picklist Print

Thursday, March 03, 2011 8:43:46 AM

Page 1

Work Order ID: 66939

Parent Item: D2022-101

Parent Item Name: Spacer



Start Date: 3/3/2011

Required Date: 3/11/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP ☐ D ☐ 02.03.07 ☐ Now made in house ☐ NG ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750 		Purchased	No			100	f	46.1898	0.03	1.2		11/3/10	
6061-T6 Round Bar .750"													

Location

Loc Qty

Loc Code

MAT	46.173	
115469	0.0027	
115869	2.4453	
116406	43.725	
MAT012	0.016842105	
112442	0.01684211	

1.8 At

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

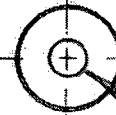
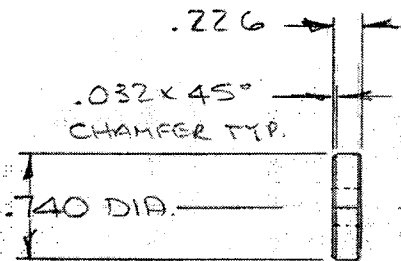
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 46939

RELEASED
970119 BW

pl 11-08-3



DRILL 'F' (.257) DIA. IN -101
DRILL P (.323) DIA. IN -103

D2022-101
D2022-103

MAT'L: ALUMINUM 6061-T6 (QQ-A-225/B)



D2022

D2022-103	SPACER 5/16 ALUM 6061-T6	QQ-A-250/B
D2022-101	SPACER 1/4 ALUM 6061-T6	QQ-A-250/B

REVISION		THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 529		QTY. REQUIRED		PART NO.		ITEM		DESCRIPTION		MATERIAL		SPEC. / VENDOR	
DRAWN				BASIC CODE		DIA. DIM. NO. 1/16" HEAD BEAR DIA. 1/16" TAIL DIA. 1/16"		APPROVAL		CONTRACT NO.		DATE		CLIENT		DART AERO ACCESSORIES INC	
APPROVED				D-CHAMF. 0.032 X 45°		LENGTH DIM. NO. 1/16" TAIL DIA. 1/16"				DRAWN BRADLEY		DATE 9/20/15					
DESCRIPTION OF CHANGE		REQUIREMENTS - UNLESS OTHERWISE SPECIFIED		BASIC CODES						DESIGN BRADLEY				TITLE SPACERS			
		1. DIMENSIONS ARE IN INCHES 2. SURFACE FINISHES 125 3. READING DIM. EDGES 0.015 MAX 4. THREADS PER UNF - 2 - 7742 5. HOLES PER AND 10887		1. TOLERANCES - AS B. 230 2. ANGLES - AS B. 210 3. PARALLELISM - 0.005 4. PERPENDICULARITY - 0.005 5. SYMMETRY ABOUT ALL HVC CENTER LINES 005		BASIC CODES				CHECKED				CODE		D2022	
										CLIENT				SCALE 1:1		SHT 1 OF 1	
REPORT ALL DISCREPANCIES - DO NOT SCALE																	

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